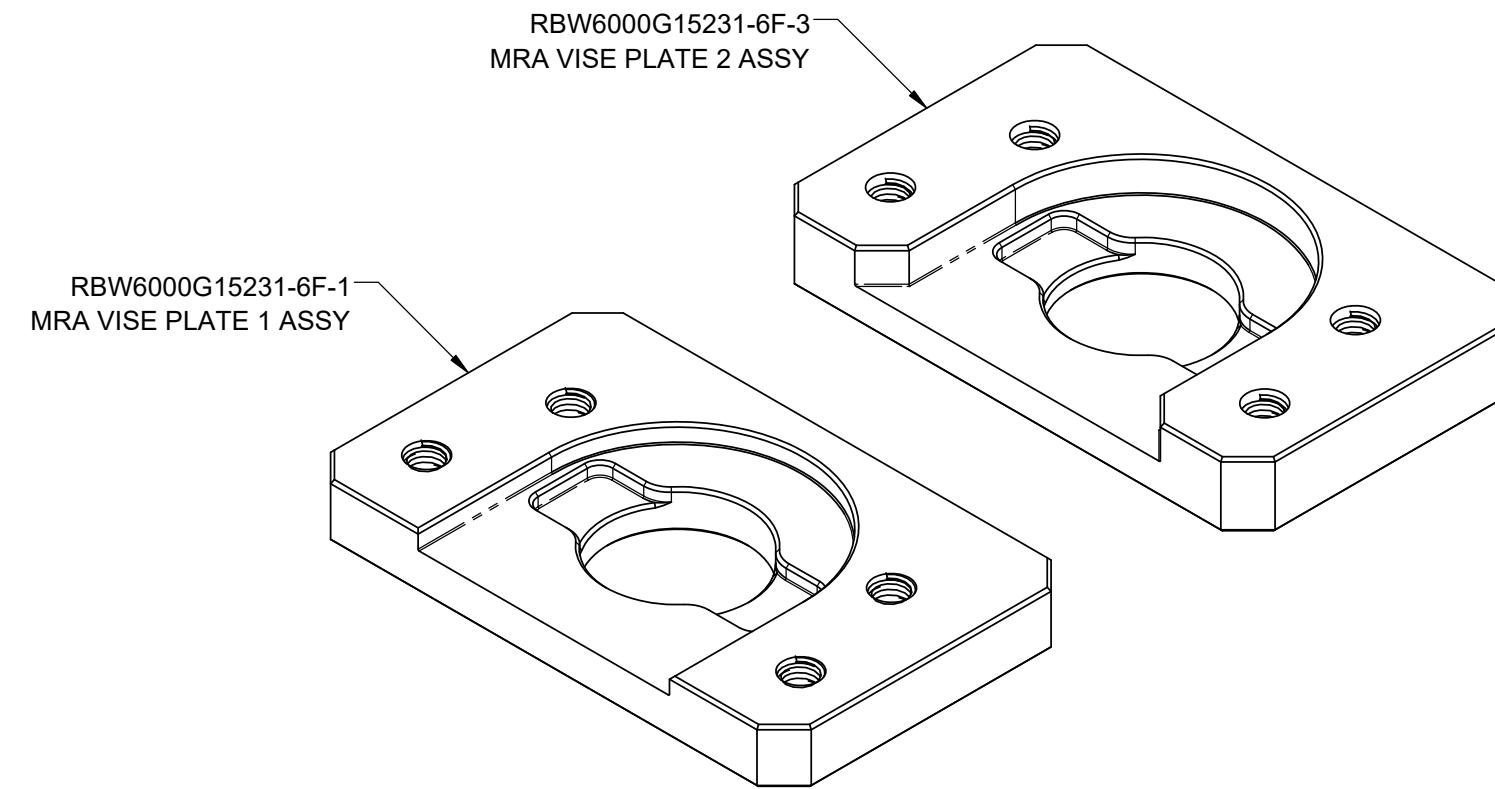
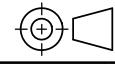


QTY	P/N	DESCRIPTION
X	RBW6000G15231-6F	MRA VISE ASSY
1	RBW6000G15231-6F-1	MRA VISE PLATE 1 ASSY
1	RBW6000G15231-6F-3	MRA VISE PLATE 2 ASSY



RBW6000G15231-6F MRA VISE ASSY

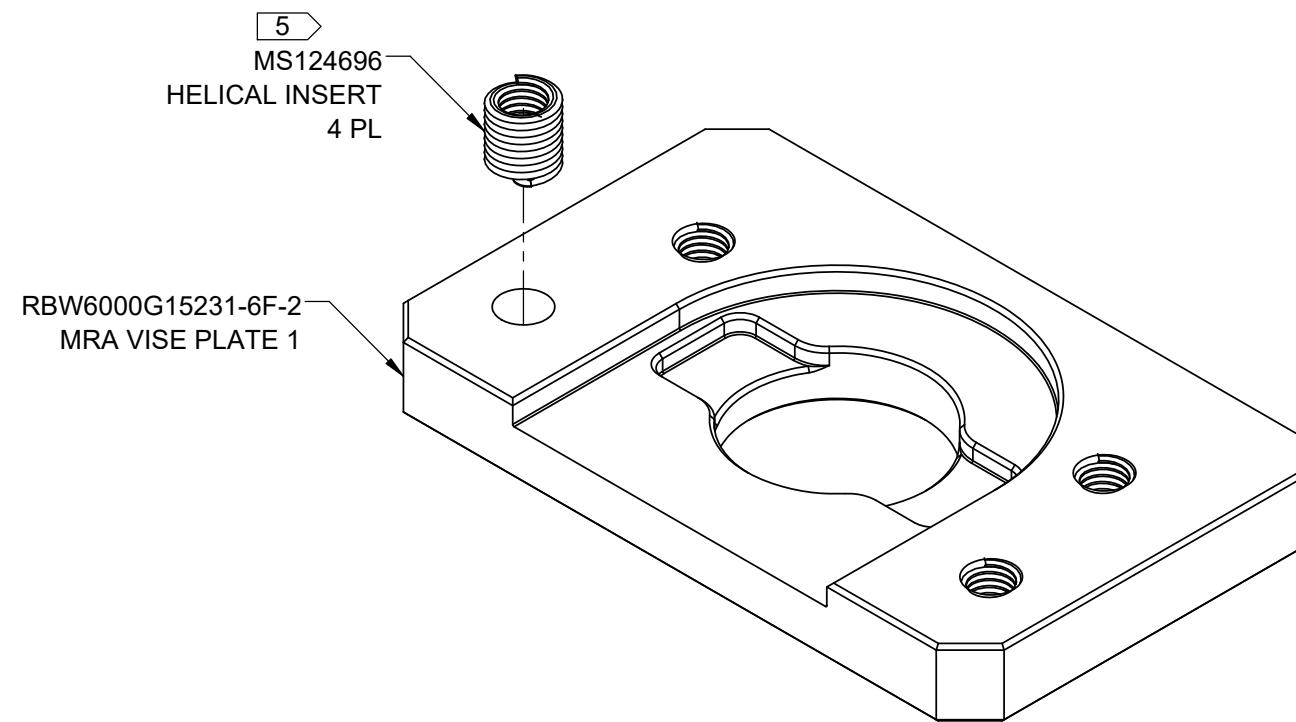
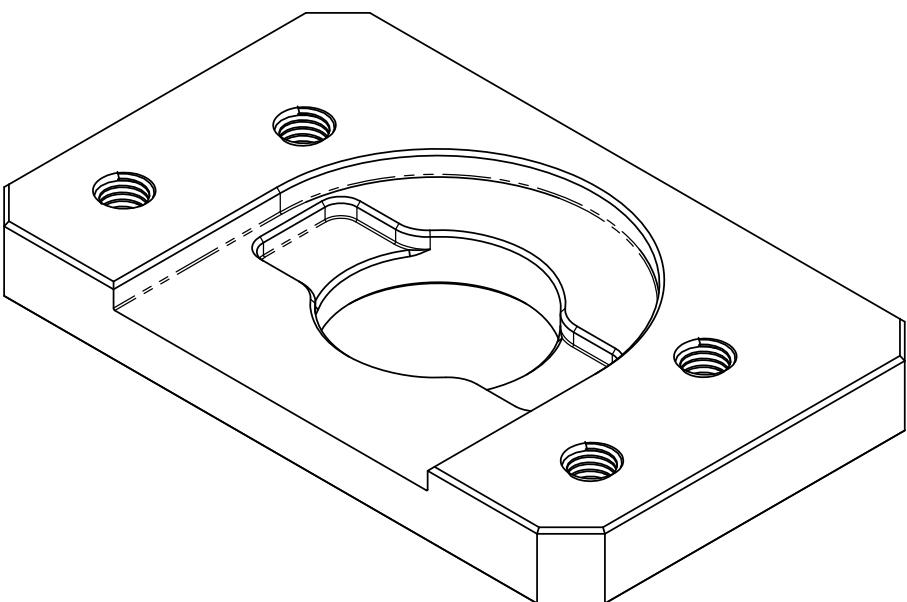
NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: NONE
 4) IDENTIFICATION: N/A

B	REVISED DRAWING TEMPLATE REORGANIZED/ADDED VIEWS FOR CLARITY -1, -3 MS124696 WAS MS21209F4-15. ADDED NOTE FOR LOCTITE 262 APPLICATION -2, -4 ADDED SYMMETRIC TOLERANCE FOR CENTER TO CENTER DIMENSIONS REASON: ECR 349			RF	22.01.13
A	NEW ISSUE			VM	19.08.13
REV.	DESCRIPTION			BY	DATE
	DESIGN	VM	UNLESS OTHERWISE NOTED	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF	DIMENSIONS IN INCHES	DRAWING NO. RBW6000G15231-6F	
	CHECKED	KPT	TOLERANCES:	REV. B SHEET 1 OF 5	
	MFG. APPR.	RQ	XX = $\pm 0.1 / \pm 1.0^\circ$ XXX = $\pm 0.01 / \pm 0.5^\circ$ XXXX = $\pm 0.005 / \pm 0.1^\circ$ XXXXX = $\pm 0.0005 / \pm 0.05^\circ$ PARALLELISM, ECCENTRICITY, AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 BREAK SHARP EDGES: 0.005 - 0.010	TITLE MRA VISE ASSY	
	APPROVED	SAD		SCALE NTS	
	DE APPR.	N/A		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
	DATE	22.01.13	 THIRD ANGLE PROJECTION		

8 7 6 5 4 3 2 1

QTY -1	P/N	DESCRIPTION
X	RBW6000G15231-6F-1	MRA VISE PLATE 1 ASSY
1	RBW6000G15231-6F-2	MRA VISE PLATE 1
4	MS124696	HELICAL INSERT

B



RBW6000G15231-6F-1 MRA VISE PLATE 1 ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: NONE
- 4) IDENTIFICATION: N/A

5) APPLY LOCTITE 262 TO THREADS OF MS124696 HELICAL INSERT PRIOR TO INSTALLATION

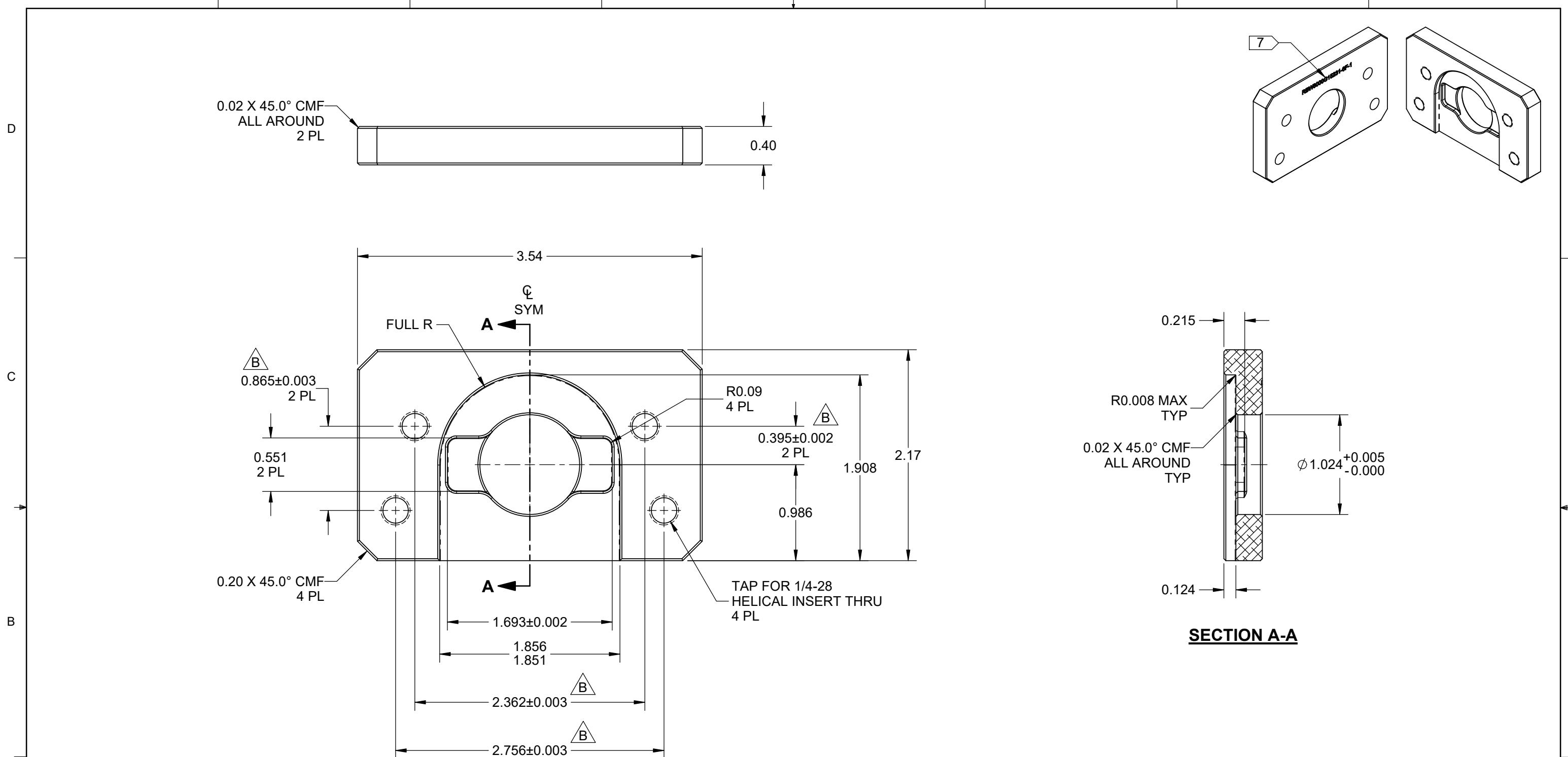
DESIGN	VM	UNLESS OTHERWISE NOTED DIMENSIONS IN INCHES TOLERANCES: XX = ±0.1 / ±1.0° XXX = ±0.01 / ±0.5° XXXX = ±0.005 / ±0.05° PARALLELISM, ECCENTRICITY, AND SYMMETRY ABOUT ALL CENTER LINES = ±0.005 BREAK SHARP EDGES: 0.005 - 0.010	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. RBW6000G15231-6F REV. B SHEET 2 OF 5 TITLE MRA VISE ASSY NTS
DRAWN	RF		
CHECKED	KPT		
MFG. APPR.	RQ		
APPROVED	SAD		
DE APPR.	N/A		
DATE	22.01.13		



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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



RBW6000G15231-6F-2 MRA VISE PLATE 1

NOTES:
1) MATERIAL: 6061-T6 OR 7075-T6 ALUMINUM BAR
2) HEAT TREAT: N/A

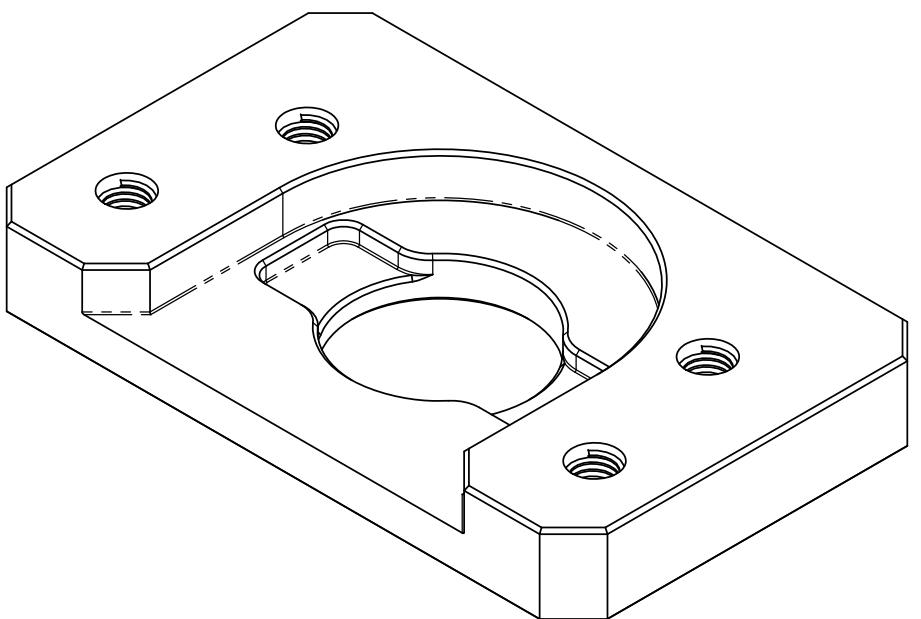
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE II, CLASS 2
4) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK P/N, "RBW6000G15231-6F-1", AS SHOWN

DESIGN	VM	UNLESS OTHERWISE NOTED	DART AEROSPACE LTD
DRAWN	RF	DIMENSIONS IN INCHES	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOLERANCES: XX = ±0.1 / ±1.0° XXX = ±0.01 / ±0.5° XXXX = ±0.005 / ±0.1° XXXXX = ±0.0005 / ±0.05° PARALLELISM, ECCENTRICITY, AND SYMMETRY ABOUT ALL CENTER LINES = ±0.005 BREAK SHARP EDGES: 0.005 - 0.010	DRAWING NO.
MFG. APPR.	RQ		REV. B
APPROVED	SAD		RBW6000G15231-6F
DE APPR.	N/A		SHEET 3 OF 5
DATE	22.01.13	THIRD ANGLE PROJECTION	TITLE
			MRA VISE ASSY
			NTS
			COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

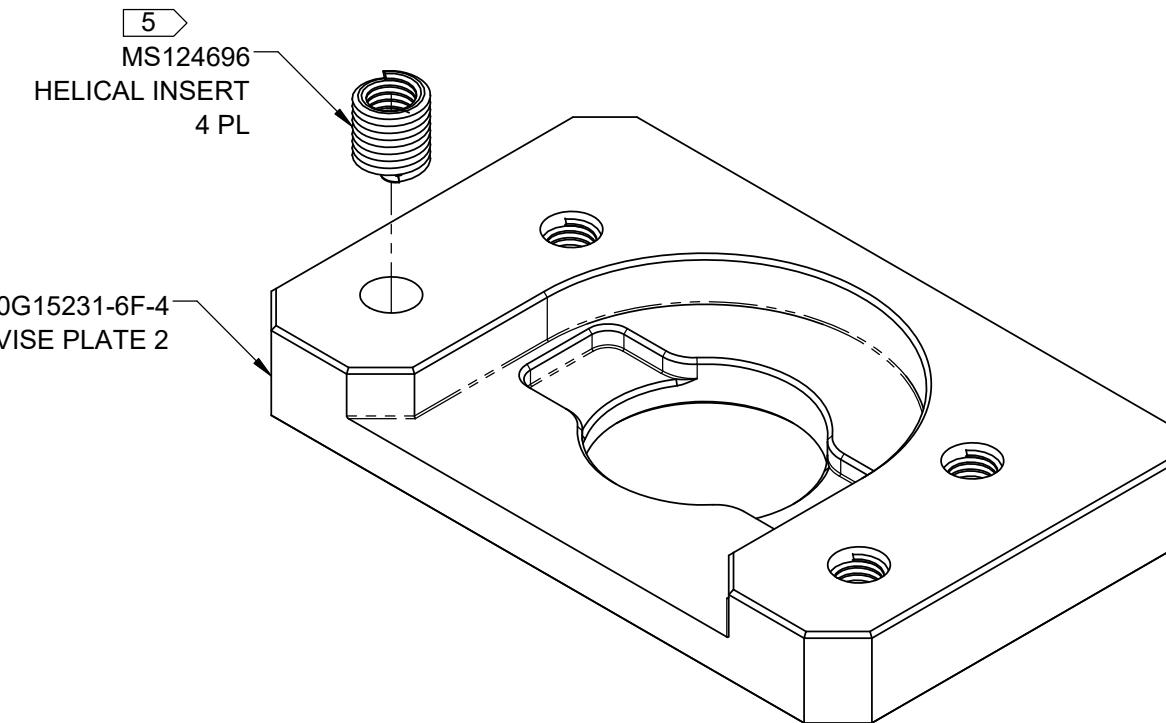
8 7 6 5 4 3 2 1

QTY -3	P/N	DESCRIPTION
X	RBW6000G15231-6F-3	MRA VISE PLATE 2 ASSY
1	RBW6000G15231-6F-4	MRA VISE PLATE 2
4	MS124696	HELICAL INSERT

B



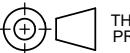
RBW6000G15231-6F-3 MRA VISE PLATE 2 ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: NONE
 - 4) IDENTIFICATION: N/A
 - 5) APPLY LOCTITE 262 TO THREADS OF MS124696 HELICAL INSERT PRIOR TO INSTALLATION

B

8 7 6 5 4 3 2 1

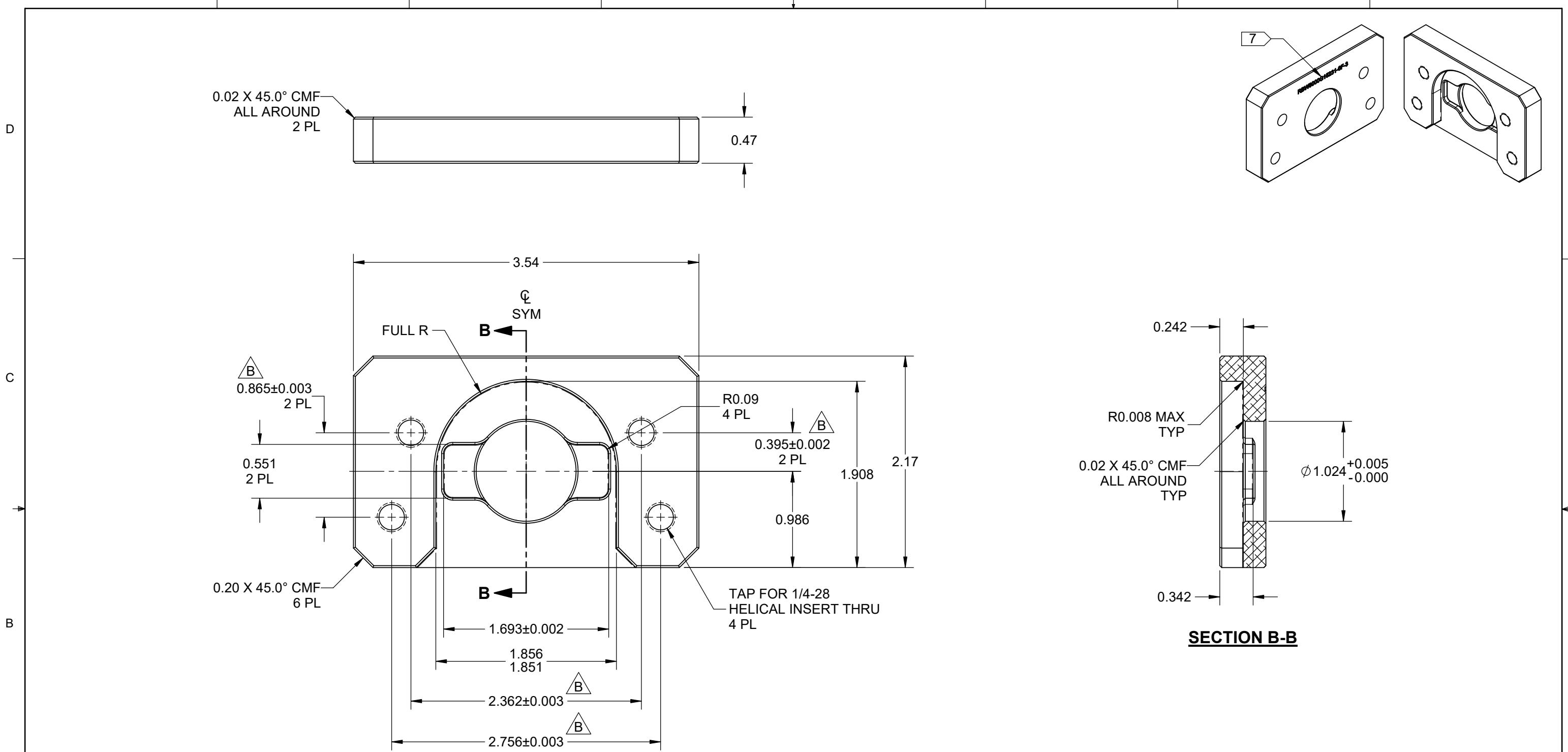
DESIGN	VM	UNLESS OTHERWISE NOTED DIMENSIONS IN INCHES TOLERANCES: XXX = ±0.1 / ±1.0° XXX = ±0.01 / ±0.5° XXXX = ±0.005 / ±0.1° XXXXX = ±0.0005 / ±0.05° PARALLELISM, ECCENTRICITY, AND SYMMETRY ABOUT ALL CENTER LINES = ±0.005 BREAK SHARP EDGES: 0.005 - 0.010	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF		
CHECKED	KPT		
MFG. APPR.	RQ		
APPROVED	SAD		
DE APPR.	N/A		
DATE	22.01.13		
		 THIRD ANGLE PROJECTION	DRAWING NO. RBW6000G15231-6F REV. B SHEET 4 OF 5
			TITLE MRA VISE ASSY NTS

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8 7 6 5 4 3 2 1

1

8 7 6 5 4 3 2 1



RBW6000G15231-6F-4 MRA VISE PLATE 2

NOTES:
 1) MATERIAL: 6061-T6 OR 7075-T6 ALUMINUM BAR
 2) HEAT TREAT: N/A

3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE II, CLASS 2
 4) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK P/N, "RBW6000G15231-6F-3", AS SHOWN

DESIGN	VM	UNLESS OTHERWISE NOTED DIMENSIONS IN INCHES TOLERANCES: XX = ±0.1 / ±1.0° XXX = ±0.01 / ±0.5° XXXX = ±0.005 / ±0.1° PARALLELISM, ECCENTRICITY, AND SYMMETRY ABOUT ALL CENTER LINES = ±0.005 BREAK SHARP EDGES: 0.005 - 0.010	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF		
CHECKED	KPT		
MFG. APPR.	RQ		
APPROVED	SAD		
DE APPR.	N/A		
DATE	22.01.13		

DRAWING NO. **RBW6000G15231-6F** REV. B SHEET 5 OF 5

TITLE **MRA VISE ASSY** SCALE NTS

THIRD ANGLE PROJECTION

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